

Date: Wednesday, 3/7/2007 8:38:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 31033		
Estimate Number	: 10310		
P.O. Number	: <i>NA</i>	Part Number	: D26175
This Issue	: 3/7/2007	S.O. No.	: <i>NA</i>
Prsht Rev.	: NC	Drawing Number	: D2617 REV D2
First Issue	: <i>NA</i>	Project Number	: N/A
Previous Run	: 30881	Drawing Revision	: D2
		Material	: <i>P/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 3/20/2007
Checked & Approved By	: <i>[Signature]</i> 07.03.07	Qty:	20 Um: Each
Comment	: Est H 04.07.14 Reformat; added step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
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Comment: Qty.: 0.0205 f(s)/Unit Total: 0.4095 f(s)

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall

M6061T6T0.500W.058)

Batch *M102765*

J.F. 07/04/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

J.F. 07/04/11 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/04/11 (20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 07/04/11 20

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

[Signature] 07-04-12 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31033

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/4/13 SA



20

Comment: INSPECT ALODINE

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/4/13 SA

8.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

207/04/16

Job Completion



U 87-04-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

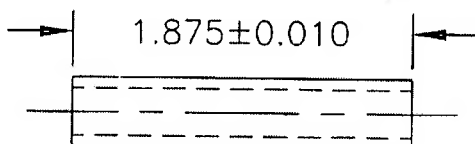
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

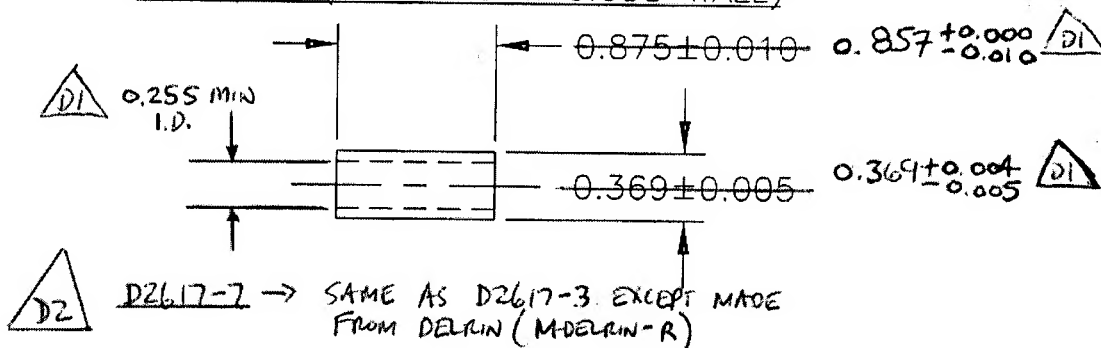


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04		TITLE BUSHING SCALE 1:1	
DZ	04.09.10 #CP	ADD D2617-7	
A	96.10.08	NEW ISSUE	
B	97.05.08	.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
DI	CP # 04.07.12	CORRECT TOLERANCE (NCR 779)	

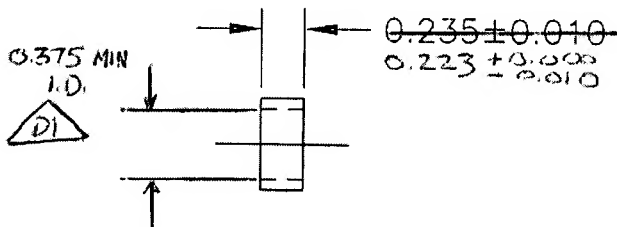
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31033

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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